

Work Order ID 102352

102352

Page 1

May-28-13 8:42:53 AM

Item ID: D3884-1

Accept

N900040100

Se

Setup Star

NS1

Revision ID:

Item Name: Saddle, Inboard LH

Stop

NS2

Start Date: 5/21/13

Start Qty: 12.00

12

Cust Item ID

Required Date: 5/27/13

Req'd Qty: 12.00

12

Customer:

Reference:

Approvals

Process Plan: MLJ

Date: 13-05-27

Tooling

Date:

R

Star

NR1

Stop

ND2

NCR: Yes / No

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: _____			DISPOSITION		AGAINST DEPARTMENT/PROCESS						
			Rework <input type="checkbox"/>	Scrap <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>			
			Use-as-is <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Quality <input type="checkbox"/>			
			Work Order Update <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Finishing <input type="checkbox"/>	Composite <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>			
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Doc/Data											
Equip/Tooling											
Operator											
Material											
Setup											
Other											
Process											
Supplier											
Training											
Unapproved											
FAULT CATEGORY											
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube				General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio		<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions				<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Other	

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____			DISPOSITION			AGAINST DEPARTMENT/PROCESS					
			Rework <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>				
Part No. _____			Scrap <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Quality <input type="checkbox"/>				
NCR No. _____			Use-as-is <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>				
Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector	
Doc/Data											
Equip/Tooling											
Operator											
Material											
Setup											
Other											
Process											
Supplier											
Training											
Unapproved											
FAULT CATEGORY											
Landing Gear				General							
Bending		Bend		<input type="checkbox"/>	Grain		<input type="checkbox"/>	Ovalized		<input type="checkbox"/>	Pressure/Forced
Centre Not Concentric to O/S		BOM/Route		<input type="checkbox"/>	Hardware		<input type="checkbox"/>	Over/Under tolerance		<input type="checkbox"/>	Temperature/Cure
Cracks		Broken/Damaged		<input type="checkbox"/>	Inspection Incomplete		<input type="checkbox"/>	Part Incorrect		<input type="checkbox"/>	Weld
Crushed/Crimped		Burrs		<input type="checkbox"/>	Instructions Incomplete/Unclear		<input type="checkbox"/>	Part Lost/Missing		<input type="checkbox"/>	Wrong Stock Pulled
Cuffs		Contamination		<input type="checkbox"/>	Maintenance		<input type="checkbox"/>	Part Moved		<input type="checkbox"/>	
Heat Treat		Countersink		<input type="checkbox"/>	Mislabeled		<input type="checkbox"/>	Positioned Wrong		<input type="checkbox"/>	
Inspection Strip in Tube		Cut Too Short		<input type="checkbox"/>	Misread		<input type="checkbox"/>	Power Loss/Surge		<input type="checkbox"/>	Other
Ripples in Bend		Drill Holes		<input type="checkbox"/>	Offset						
Torque Waves in Extrusion		Drawing		<input type="checkbox"/>	Out of Calibration						
Turning Sequence		Finish		<input type="checkbox"/>	Out of Sequence						
Wave/Twist in Tube		Folio		<input type="checkbox"/>	Outside Dimensions						

Work Order ID 102352

102352

May-28-13 8:42:53 AM

Page 3

Item ID: D3884-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Saddle, Inboard LH

Start Date: 5/21/13 Start Qty: 12.00

12

Cust Item ID:

Required Date: 5/27/13 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

QC3- Inspect Part Finish

0.00

11/6 13-6-10

150

QC

Quality Control

160

Identify as per dwg & Stock Location: ST429

0.00

R 11/6 13-06-11

160

Packaging

Packaging

170

QC21- Final Inspection - Work Order Release

0.00

MWS 13-06-11

170

QC

Quality Control

11/6 13-06-11

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: Date:

QA Closed: _____ **Date:** _____

Work Order: _____				DISPOSITION		AGAINST DEPARTMENT/PROCESS					
				Rework <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>			
				Scrap <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Quality <input type="checkbox"/>			
				Use-as-is <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>			
				Work Order Update <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>				
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Doc/Data											
Equip/Tooling											
Operator											
Material											
Setup											
Other											
Process											
Supplier											
Training											
Unapproved											
FAULT CATEGORY											
Landing Gear				General							
Bending	Bend	Grain	Ovalized	Pressure/Forced							
Centre Not Concentric to O/S	BOM/Route	Hardware	Over/Under tolerance	Temperature/Cure							
Cracks	Broken/Damaged	Inspection Incomplete	Part Incorrect	Weld							
Crushed/Crimped	Burrs	Instructions Incomplete/Unclear	Part Lost/Missing	Wrong Stock Pulled							
Cuffs	Contamination	Maintenance	Part Moved								
Heat Treat	Countersink	Mislabeled	Positioned Wrong								
Inspection Strip in Tube	Cut Too Short	Misread	Power Loss/Surge								
Ripples in Bend	Drill Holes	Offset	Other								
Torque Waves in Extrusion	Drawing	Out of Calibration									
Turning Sequence	Finish	Out of Sequence									
Wave/Twist in Tube	Folio	Outside Dimensions									

Picklist Print

May-28-13 8:42:52 AM

Page 1

Work Order ID: 102352

Parent Item: D3884-1

Parent Item Name: Saddle, Inboard LH

Start Date: 5/21/13

Required Date: 5/27/13

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP RevA: New issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-017 Saddle Billet		Manufactured	No				Each	11.0000		12		SL 13-6-9	

Location	Loc Qty	Loc Code
MAT040	11	
94444	11	/ /

NCR: Yes / No

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order: _____			DISPOSITION		AGAINST DEPARTMENT/PROCESS					
			Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/>	Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/>	Water Jet <input type="checkbox"/> Prod. Eng. Coor. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/>	Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/>			
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector	
Doc/Data <input type="checkbox"/> Equip/Tooling <input type="checkbox"/> Operator <input type="checkbox"/> Material <input type="checkbox"/> Setup <input type="checkbox"/> Other <input type="checkbox"/> Process <input type="checkbox"/> Supplier <input type="checkbox"/> Training <input type="checkbox"/> Unapproved <input type="checkbox"/>										
FAULT CATEGORY										
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube <input type="checkbox"/>	General									
	<input type="checkbox"/> Bend	<input type="checkbox"/> Grain	<input type="checkbox"/> Ovalized	<input type="checkbox"/> Pressure/Forced						
	<input type="checkbox"/> BOM/Route	<input type="checkbox"/> Hardware	<input type="checkbox"/> Over/Under tolerance	<input type="checkbox"/> Temperature/Cure						
	<input type="checkbox"/> Broken/Damaged	<input type="checkbox"/> Inspection Incomplete	<input type="checkbox"/> Part Incorrect	<input type="checkbox"/> Weld						
	<input type="checkbox"/> Burrs	<input type="checkbox"/> Instructions Incomplete/Unclear	<input type="checkbox"/> Part Lost/Missing	<input type="checkbox"/> Wrong Stock Pulled						
	<input type="checkbox"/> Contamination	<input type="checkbox"/> Maintenance	<input type="checkbox"/> Part Moved							
	<input type="checkbox"/> Countersink	<input type="checkbox"/> Mislabeled	<input type="checkbox"/> Positioned Wrong							
	<input type="checkbox"/> Cut Too Short	<input type="checkbox"/> Misread	<input type="checkbox"/> Power Loss/Surge							
	<input type="checkbox"/> Drill Holes	<input type="checkbox"/> Offset	<input type="checkbox"/> Other							
	<input type="checkbox"/> Drawing	<input type="checkbox"/> Out of Calibration								
	<input type="checkbox"/> Finish	<input type="checkbox"/> Out of Sequence								
	<input type="checkbox"/> Folio	<input type="checkbox"/> Outside Dimensions								

DART AEROSPACE LTD				Work Order:	102352
Description: Saddle, Inboard, LH				Part Number:	D3884-1
Inspection Dwg: D3884 Rev. B				Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	2.870	2.880		2.875	2.875	2.875	2.875		
B	1.433	1.443		1.438	1.438	1.438	1.438		
C	0.638	0.658		-646	-649	-648	-649		
D	3.895	3.905		3.900	3.900	3.900	3.900		
E	0.257	0.262		-258	-258	-258	-258		
F	0.605	0.625		613	-616	-615	-616		
G	1.120	1.130		1.125	1.125	1.125	1.125		
H	2.245	2.255		2.250	2.250	2.250	2.250		
I	2.000	2.020		2.001	2.002	2.003	2.003		
J	0.140	0.175		-151	-150	-149	-150		
K	1.265	1.285		1.266	1.267	1.268	1.268		
L	0.115	0.135		126	-125	-126	-126		
M	0.240	0.260		-250	-250	-250	-251		
N	0.110	0.140		-140	-140	-140	-140		
O	0.240	0.260		252	-250	-250	-250		
P	2.826	2.886		2.856	2.856	2.856	2.856		
Q	0.178	0.198		-188	-188	-188	-188		
R	0.140	0.165		-152	-151	-152	-152		
S	0.720	0.780		-780	-780	-780	-780		
T	1.220	1.280		1.250	1.250	1.250	1.250		
U	1.245	1.255		1.250	1.250	1.250	1.250		
V	5.990	6.010		6.000	5.999	6.000	6.000		
W	2.495	2.505		2.500	2.500	2.500	2.500		
X	0.490	0.510		-498	-499	-497	-500		
Y	0.020	0.040		-030	-030	-030	-030		
Z	0.313	0.318		-314	-314	-314	-314		
AA	0.760	0.765		-760	-760	-760	-760		
AB	0.215	0.220		-217	-217	-217	-217		
AC	0.316	0.321		-316	-316	-316	-316		
AD	1.745	1.755		1.750	1.750	1.750	1.750		
AE	0.990	1.010		-998	1.003	1.001	1.003		
AF									
Accept/Reject									

Measured by:	SL	Audited by:	GM
Date:	13-6-8	Date:	13/06/10

Rev	Date	Change	Revised by	Approved
A	09.10.22	New Issue	KJ	CF

DART AEROSPACE LTD	Work Order:	102357
Description: Saddle, Inboard, LH	Part Number:	D3884-1
Inspection Dwg: D3884	Rev. B	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				15	16	17	18		
A	2.870	2.880		2.875	2.875	2.875	2.875		
B	1.433	1.443		1.438	1.438	1.438	1.438		
C	0.638	0.658		-648	-648	-649	-648		
D	3.895	3.905		3.900	3.900	3.900	3.900		
E	0.257	0.262		-258	-258	-258	-258		
F	0.605	0.625		-615	-615	-616	-615		
G	1.120	1.130		1.125	1.125	1.125	1.125		
H	2.245	2.255		2.250	2.250	2.250	2.250		
I	2.000	2.020		2.003	2.003	2.003	2.002		
J	0.140	0.175		-149	-150	-150	-151		
K	1.265	1.285		1.268	1.268	1.268	1.267		
L	0.115	0.135		-126	-126	-125	-126		
M	0.240	0.260		-251	-251	-250	-250		
N	0.110	0.140		-140	-140	-140	-140		
O	0.240	0.260		-250	-250	-250	-249		
P	2.826	2.886		2.856	2.856	2.856	2.856		
Q	0.178	0.198		-188	188	-188	-188		
R	0.140	0.165		-151	-152	-151	-152		
S	0.720	0.780		-780	-780	-780	-780		
T	1.220	1.280		1.250	1.250	1.250	1.250		
U	1.245	1.255		1.250	1.250	1.250	1.250		
V	5.990	6.010		5.999	6.000	6.000	6.000		
W	2.495	2.505		2.500	2.500	2.500	2.500		
X	0.490	0.510		-497	-496	-497	-497		
Y	0.020	0.040		-030	-030	-030	-030		
Z	0.313	0.318		-314	-314	-314	-314		
AA	0.760	0.765		-760	-760	-760	-766		
AB	0.215	0.220		-217	-217	-217	-217		
AC	0.316	0.321		-316	-316	-316	-316		
AD	1.745	1.755		1.750	1.750	1.750	1.750		
AE	0.990	1.010		1.001	1.001	1.002	1.001		
AF									
Accept/Reject									

Measured by:	<u>S</u>	Audited by:	<u>CMZ</u>
Date:	13-6-9	Date:	13/10/11/10

Rev	Date	Change	Revised by	Approved
A	09.10.22	New Issue	KJ	<u>CMZ</u>

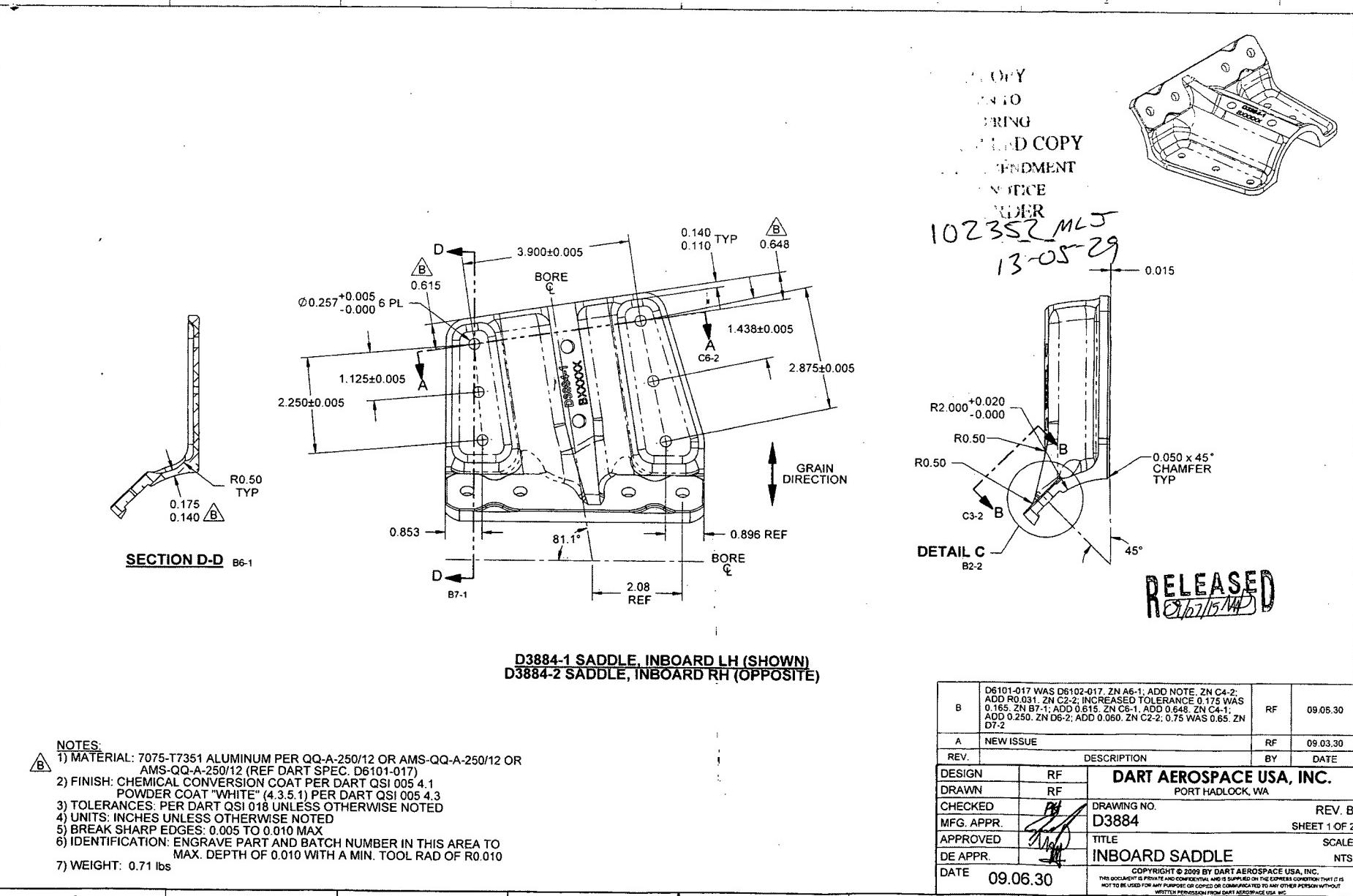
DART AEROSPACE LTD				Work Order:	102352
Description: Saddle, Inboard, LH				Part Number:	D3884-1
Inspection Dwg: D3884 Rev. B				Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing and record below:

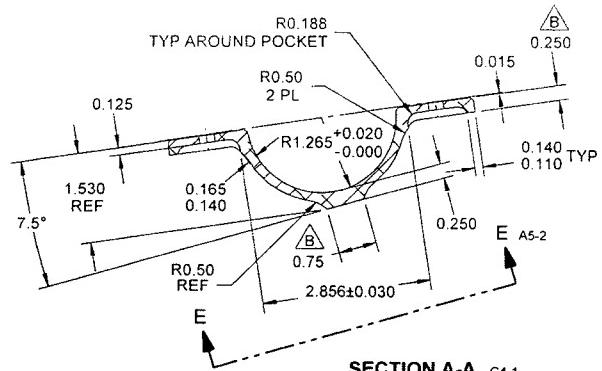
Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				19	210	311	4		
A	2.870	2.880		2.875	2.875	2.875			
B	1.433	1.443		1.438	1.438	1.438			
C	0.638	0.658		.650	.648	.648			
D	3.895	3.905		3.900	3.900	3.900			
E	0.257	0.262		.258	.258	.258			
F	0.605	0.625		.617	.615	.615			
G	1.120	1.130		1.125	1.125	1.125			
H	2.245	2.255		2.250	2.250	2.250			
I	2.000	2.020		2.003	2.003	2.003			
J	0.140	0.175		.150	.150	.151			
K	1.265	1.285		1.268	1.268	1.268			
L	0.115	0.135		.126	.126	.126			
M	0.240	0.260		.251	.251	.251			
N	0.110	0.140		.140	.140	.140			
O	0.240	0.260		.251	.251	.250			
P	2.826	2.886		2.856	2.856	2.856			
Q	0.178	0.198		.188	.188	.188			
R	0.140	0.165		.152	.152	.152			
S	0.720	0.780		.780	.780	.780			
T	1.220	1.280		1.250	1.250	1.250			
U	1.245	1.255		1.250	1.250	1.250			
V	5.990	6.010		6.000	6.000	6.000			
W	2.495	2.505		2.500	2.500	2.500			
X	0.490	0.510		.501	.501	.500			
Y	0.020	0.040		.030	.030	.030			
Z	0.313	0.318		.314	.314	.314			
AA	0.760	0.765		.760	.760	.760			
AB	0.215	0.220		.217	.217	.214			
AC	0.316	0.321		.316	.316	.316			
AD	1.745	1.755		1.750	1.750	1.750			
AE	0.990	1.010		1.003	1.003	1.003			
AF									
Accept/Reject									

Measured by:	SL	Audited by:	CM
Date:	13-6-9	Date:	13/6/10

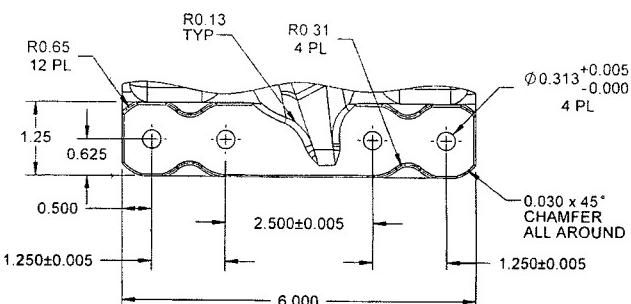
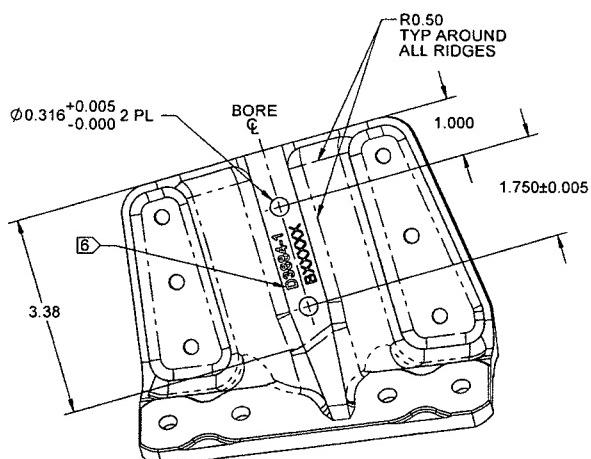
Rev	Date	Change	Revised by	Approved
A	09.10.22	New Issue	KJ	CM



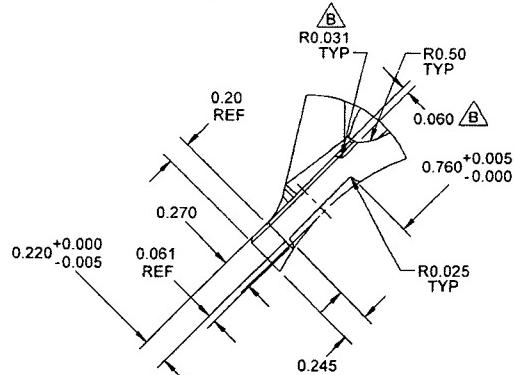
102352



SECTION A-A C4-1

VIEW B-B B3-1
B (ROTATED FOR CLARITY)

VIEW E-E C6-2

DETAIL C B3-1
SCALE 2XRELEASED
09/07/15

DESIGN	RF	DART AEROSPACE USA, INC.
DRAWN	RF	PORT HADLOCK, WA
CHECKED	PJ	REV. B
MFG. APPR.		D3884 SHEET 2 OF 2
APPROVED	WWD	TITLE
DE APPR.	MM	SCALE
DATE	09.06.30	NTS

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